

Date: Thursday, 16/08/2007 11:32:14 AM  
User: Linda Lacelle

## Process Sheet

Split w/o  
SB 07/08/20

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34018 -1  
Est mate Number : 10334  
P.C. Number : NA  
This Issue : 16/08/2007 S.O. No. : NA  
Prsht Rev. : NC  
First Issue : NA Type : R & D SM/MED FAB  
Previous Run : 29409  
Written By :  
Checked & Approved By :  
Comment : Est F 05/03/30 MS21043-3 was MS21042L3 KJ/JLM  
Est Rev:G As per Rev C 06-11-08 JLM

Drawing Name : BRACKET ASSEMBLY  
Part Number : D2804042  
Drawing Number : D2804 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : NA  
Due Date : 05/09/2007  
Qty: 13  
20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28042 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number  
1 D2804-2

Description  
Bracket

Batch

B 28310 (4)

B 26645 (4)

B 29410 (5)

SB 07/11/22

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Stop

Pick:

Qty Part Number  
1 D2805-2

Description

Batch

Stop

B 33600

B 34033

SB 07/11/22

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number  
1 D2809

Description  
Bushing

Batch

B 30149

SB 07/11/22

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 & D2809 into arm as per Dwg D2804

x13  
ml 07/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/20	1	Split W/O 13 required for work on -1 7 on -2 W/O.	SB	07/08/20	13	<i>[Signature]</i> 07-11-22	<i>[Signature]</i> 07-11-22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/22	3	1 part of B3809 B30749 is out of tolerance Smaller of .015"	<i>[Signature]</i> 07/11/22	Scrap + replace it destroy	SB 07/11/22	<i>[Signature]</i> 07/11/22	<i>[Signature]</i> 07/11/22	<i>[Signature]</i> 07/11/22

NOTE: Date & initial all entries



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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34018

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*For 11-22 (13)*

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 105914*

*BR 07-11-22*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*mf 07-11-22*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

*mf 07-11-22 (13)*

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

*7\**  
*4102552*

*12 19*  
*50*  
*M105426*

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3 Nut

*20\**  
*M105792*

*50*

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

*# 62*  
*M105164*

*7/11/22 50*

*(13)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: BRACKET ASSEMBLY

Job Number: 34018

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R

LPS-3

Corrosion Spray

m104929

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

MF 07-11-22 (13)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

KS

2/4/22 (X13)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 149

W

07/11/23

(X13)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(B)  
2/4/12

Job Completion



W 07/11/26



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

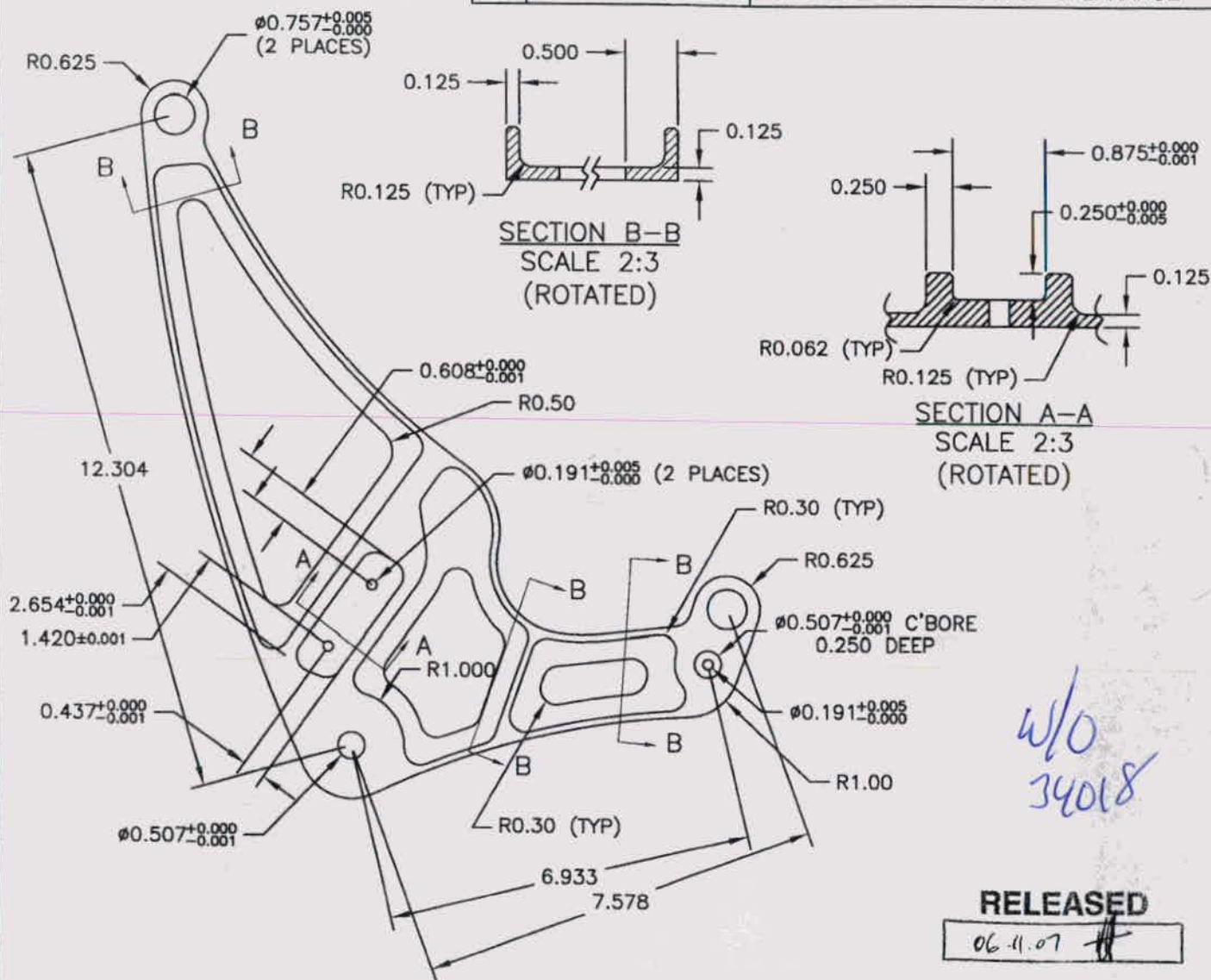
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D2804	SHEET 1 OF 2
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE			

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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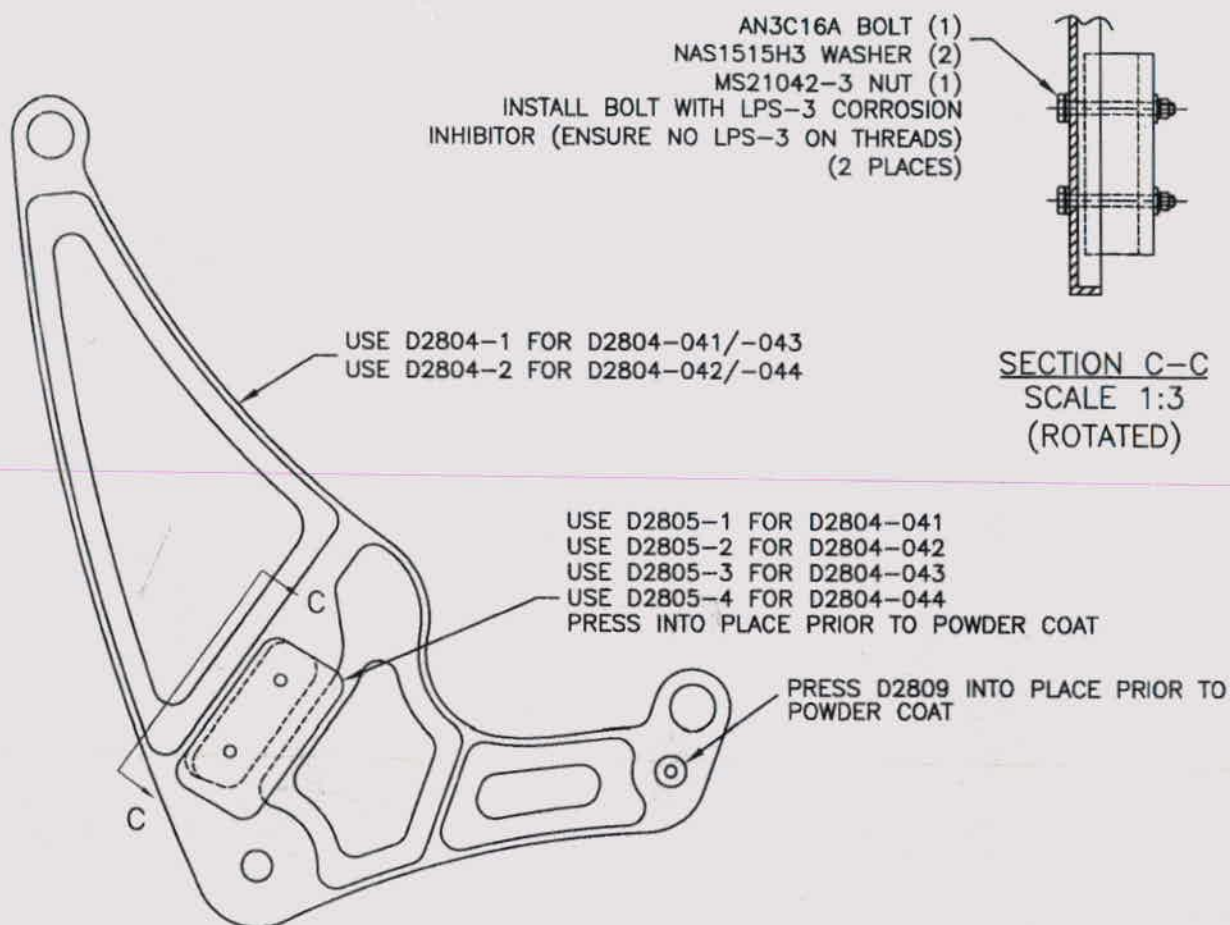
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**06-11-07 

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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